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RBE350A93-3204-00

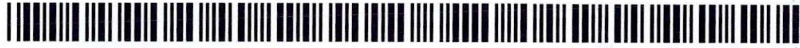
Job Sheet 194600



Part No: RBE350A93-3204-00

Job Qty: 2 pcs

Part Name: Fan Flange Extractor



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/6/19

Job Tracking No:

Due Date: 6/21/19

Created By: Marie Lajeunesse

Type: SOLD

Description: *Order 15539-15422*

Note: DWG RBE350A93-3204-00 Rev 0 IPP Rev. A 19.05.02 New issue DP Verify DD

Ship Via:

Bill of Materials



Container No: S192373



Part: RBE350A93-3204-00

Job No: 194600

Serial No/Batch: S192373

Revision: 0

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 06/20/19

Job Routing								
Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	
					Setup Hrs	Run Hrs	Workcenter / Supplier Lead Time	Sign-off
100	Small Fab - 1	2 pcs	6/21/19		0.00	0.40	Small Fab - 1	
							Small Fab - 2	MW
							Small Fab - 3	
							Small Fab - 4	
							Small Fab - 5	
							Small Fab - 6	
							Small Fab - 7	
110	QC 5	2 pcs	6/21/19		0.00	0.00	QC 5 - 10	
							QC 5 - 12	
							QC 5 - 17	
							QC 5 - 18	
							QC 5 - 19	
							QC 5 - 22	
							QC 5 - 24	
							QC 5 - 3	
							QC 5 - 43	
							QC 5 - 49	
							QC 5 - 51	
							QC 5 - 58	
							QC 5 - 68	
							QC 5 - 9	
							QC 5 - 50	
							QC 5 - 30	
							QC 5 - 40	
120	Packaging 3-1 - Stock - B4B	2 pcs	6/21/19		0.00	0.00	Packaging 3 - 1 - B4B	
							Packaging 3 - 2 - B4B	
							Packaging 3 - 3 - B4B	
							Packaging 3 - 4 - B4B	
							Packaging 3 - 5 - B4B	
							Packaging 3 - 6 - B4B	
							Packaging 3 - 7 - B4B	
							Packaging 3 - 8 - B4B	
							Packaging 3 - 9 - B4B	
							Packaging 3 - 10 - B4B	
130	QC 21 - FG	2 pcs	6/21/19		0.00	0.00	QC 21 - FG - 21	
							QC 21 - FG - 70	
							QC 21 - SA - 53	

Part Op 100 - Assemble as per DWG. See note 1.
 Descriptions:

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
91083A011	Washer	2 (1 ea)	100-Small Fab - 1	5183009
RBE350A93-3204-00-1	Base	2 pcs (1 ea)	100-Small Fab - 1	5189482
RBE350A93-3204-00-3	Disk	2 pcs (1 ea)	100-Small Fab - 1	5185025
RBE350A93-3204-00-5	Hex Head Cap Screw	2 pcs (1 ea)	100-Small Fab - 1	5184975

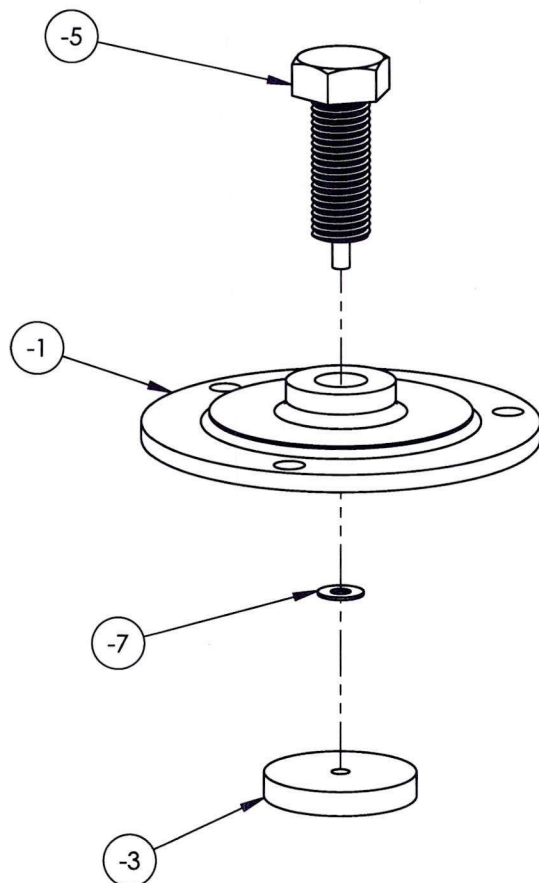
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	91083A011	2	0	0
	RBE350A93-3204-00-1	2	0	0
	RBE350A93-3204-00-3	2	0	0
	RBE350A93-3204-00-5	2	0	0

Part Specifications
Specifications could not be found.

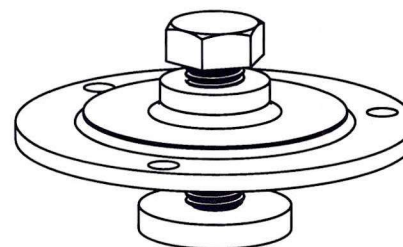
Plex 5/6/19 8:03 AM Dart.lajeunesse.marie

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED



SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 194600 MLC
19-05-06



NOTE:

1. THREAD -5 INTO -1 THEN, PLACE -3 AND -7 ONTO -5, PEEN END OF -5, ENSURING -3 ROTATES FREELY.
2. REF. OLD RB T/N: RBEA93-3204-00.

RED BARN MACHINE	
TITLE FAN FLANGE EXTRACTOR	
DWG NO. RBE350A93-3204-00	REV
MAT'L UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/32 .XX ± .01 ANGLES ± .5° .X ± .1	DRAWN BY: GILBERT APPROVED <i>D Weil</i> HEAT TREAT FINISH SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL EUROCOPTER
SCALE 1:2	DATE 5/6/2011 SHEET 1 OF 4

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	BASE	1018	Ø4-3/8 X 3/4	2
			-3	1	DISK	6061	Ø1-3/4 X 5/16	3
			-5	1	HEX HEAD CAP SCREW	STEEL	M16 X 50mm MCMaster-CARR #91180A876 (MODIFIED)	4
		B/O	-7	1	WASHER	STEEL	#10 MCMaster-CARR #91083A011	14

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐					
Date : _____		Sequence # : _____		QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation				Disposition			
				Completed By			
				Lead hand / Supervisor			
				QC / QA Coordinator			
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread					
Other/Details:							